

54491 Derev

Work Order ID 53966

November 24, 2009 11:14:41 AM



Page 1

Item ID: D2873-043

Accept

Revision ID: A

Item Name: Nut Plate Assembly

Start Date: 25/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 07/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Pt

Date: *09/11/24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2873	Rev A
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100



BAND SAW

Bandsaw

Memo

0.00

H.A 09/12/05

20 0

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

JML 09/12/07

20 0

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-3
Dwg Rev A Folio Rev A

120



QC2- Inspect parts off machine FAI/FAIB

0.00

Onf. 09/12/07

20 0

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		:					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53966

November 24, 2009 11:14:41 AM



Page 2

Item ID: D2873-043

Accept



Setup Start



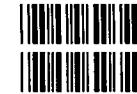
Revision ID: A

Stop



Item Name: Nut Plate Assembly

Start Date: 25/11/2009 Start Qty: 20:00



Cust Item ID:

Required Date: 07/12/2009 Req'd Qty: 20:00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

4.4 09/12/07



QC

Memo

0.00

Quality Control

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Deburr □2- C'sink as per Dwg D2873

20 6

EP09/12/08 20

150

QC5- Inspect part completeness to step on W/O

0.00

09/12/08



QC

Memo

0.00

Quality Control

cont'd 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 53966

November 24, 2009 11:14:42 AM



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Item ID: D2873-043

Accept



Setup Start



Revision ID: A

Stop



Item Name: Nut Plate Assembly

Start Date: 25/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 07/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

2) Sol. 1/2/09



QC

Memo

0.00

center
x20

d

Quality Control

200

Identify as per dwg & Stock Location: X-table

0.00



Packaging

Memo

0.00

Packaging

n 09 10 10 (20)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/10 MF 09-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

November 24, 2009 11:14:49 AM

Work Order ID: 53966



Parent Item: D2873-043RevA



Parent Item Name: Nut Plate Assembly

Start Date: 25/11/2009

Required Date: 07/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21075LS



Purchased

No

100

Each

410.0000

60.0000



Nut Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

ST

410

110916

79

112243

331

M6061T6B0.375X01.00

0



Purchased

No

180

f

17.6095

6.4905



6061T6 BAR .375 x 1.00

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

MAT

17.60947368

105225

5.3

110829

12.3094737

113325

6.1666'H.A 09/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Page 2

November 24, 2009 11:14:49 AM

Work Order ID: 53966



Parent Item: D2873-043RevA



Parent Item Name: Nut Plate Assembly

Start Date: 25/11/2009

Required Date: 07/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-6		Purchased	No			180	Each	3,930.000	120.0000		Epo9/12/09	

Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3930	
100151	27	
103395	14	
105144	88	
110139	3774	
2525	27	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53964
Description: Radius Block	Part Number:	D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>Jay</i>	Audited by:	<i>H.A.</i>	Prototype Approval:	N/A
Date:	09/12/07	Date:	09/12/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	Sgt

SHOP
REVISION
ENGINEERING
UNCONTROLLED DRAWING
SUBJECT TO AMENDMENT

WITHOUT CHARGE
WORK ORDER NO.

53966
DPOG-11-24

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